

5/30

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	<b>23731</b>
<b>Description:</b> Cover	<b>Part Number:</b>	<b>D3202-1</b>
<b>Dwg:</b> D3202 Rev. B1	<b>Qty:</b>	<b>33</b>
<b>Ref:</b>	Page 1 of 1	

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	DF	05.07.04	30
2	PG	Issue P/O: <u>2008316</u> Email or Ship DXF file to vendor Laser Cut flat pattern per Dwg D3202 Possible Supplier: GFI or Industrial Laser <b>Material release note is required</b>	W	05.07.03	40
3	RG	Receive and Inspect for transit damage <b>Enure material release note is attached</b>	DL	05/07/11	33
4	QC6	Inspect dimensions as per Dwg D3202	SB	05/08/15	33
5	GA	Deburr	SAD	05/08/15	32
6	FP	Chemical Conversion Coat as per QSI-005.4.1	SAD	05/08/18	32
7	FP	Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3	FC	05 08 24	32
8	QC3	Inspect Powder Coat	ML	05 08 26	32
9	ST	Identify and Stock	DL	05/08/26	33
10	AC	Cost / part: <u>33.05</u>	S4C	05.08.28	33
11	DC	Close W/O <u>32.54</u> Inspect Level 21	DF	05/08/29	33

Rev	Date	Change	Revised By	Approved
A	03.11.07	New issue	KJ/RF	
B	04.10.21	Laser Cut no longer made in-house	KJ/JLM	

**RELEASED**  
21/01/10-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector





NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

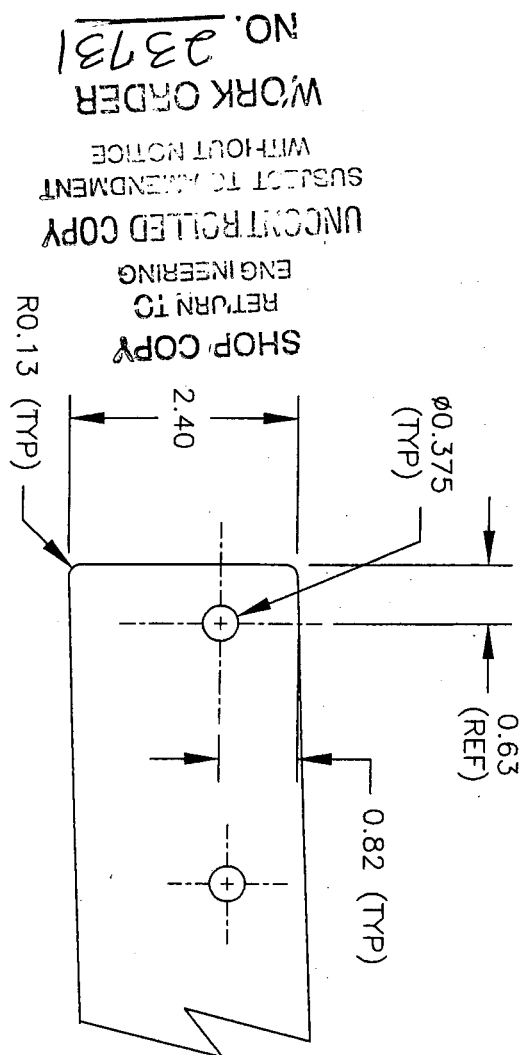
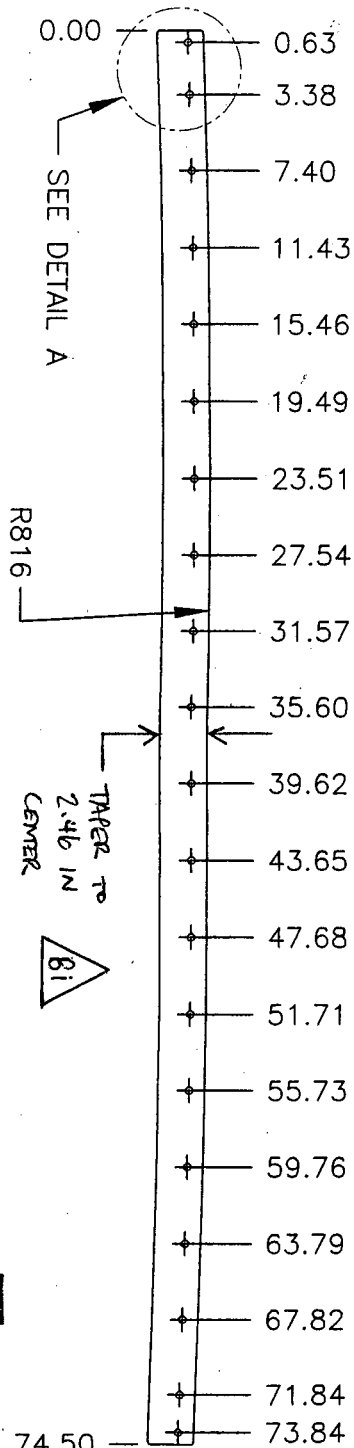
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA:   *DP*   Date:   05/08/29  

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_



DESIGN			CHECKED		APPROVED	DRAWING NO.	D3202	SHEET 1 OF 1	REV. B	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
										TITLE	SCALE
03.10.16		COVER									
A	01.01.01		NEW ISSUE								
B	03.10.16		REDESIGN; PART NOW CURVED								
BI	 04.05.14		CLARIFY MID-SPAN DIMENSION								



UNCONTROLLED COPY  
RETURN TO  
ENGINEERING  
SHOP COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 23731

DETAIL A  
SCALE 1:2

RELEASED

03.11.07

- D3202-1 COVER**
- 1) MATERIAL: 5052-H32/H34 SHEET (QQ-A-250/8) 0.032 THICK (REF DART SPEC. M5052H32S.032)
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GREY SANDEX (4.3.5.6) PER DART QSI 005 4.3
  - 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) ALL DIMENSIONS ARE IN INCHES
  - 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

# Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Jun 30, 2005  
02:06 pm

Work Order No : 0023731  
Project Name : D3202-1  
Project For : WK530  
Work Order Type : Main  
Main WO Number :  
House Part Number : D3202-1  
Description : Cover  
Manufactured : Yes  
Amount Req'd : 30  
Amount Done : 0  
Start Date : 06-30-05  
Est Finish Date : 07-30-05  
Act Finish Date :  
Drawings Req'd : No  
Ok for Approval :  
Approval Rec'd :

Department Code:  
Burden Flags : NNNNNNNN  
WO Status : Open  
Invoice State : Not Invoiced  
Invoice Date :  
Invoice Number :  
Invoice Amount : 0.00  
Order Entry No :  
OE Value : 0.00  
Est Mark Up : 0.000%  
Actual Mark Up : 0.000%  
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

# MATERIAL TEST REPORT

From: PECHINEY ROLLED PRODUCTS  
CENTURY ROAD  
P.O. BOX 68  
RAVENSWOOD, WV , 26164

Page : 1  
Heat/Lot : 351511  
TIN : 351511

Sold To: INTEGRIS METALS, LTD.  
12311 HORSESHOE WAY  
RICHMOND , BC V7A 4X6

Ship To: 3399 FRANCIS HUGHES  
LAVAL PQ  
--H7L 5

## Vendor Information

Cust PO #: 78597

Cust PO DT: 04/05/05

## Specifications

RAVENSWOOD DISTRIBUTOR  
SPEC COIL NON HT MILL  
AMS-QQ-A-250/8  
ALSO CONFORMS TO ASTM B209-04  
Buyer Part: 54582309

5052 H32 032 IN 48 IN

## Mechanical Tests

	Min	UOM	L	O	Max	UOM	L	O
Number of Tests: 2								
Ult Tensile Str, Longitudinal	34.2	KSI	LONG		35.6	KSI	LONG	
Yield Strength	26.9	KSI	LONG		29	KSI	LONG	
Elongation, Longitudinal	9.5	PCT	LONG		12	PCT	LONG	

## Chemical Composition

SI Silicon-Pct	.150	FE Iron-Pct	.200
CU Copper-Pct	.040	MN Manganese-Pct	.050
MG Magnesium-Pct	2.420	CR Chromium-Pct	.170
ZN Zinc-Pct	.010	OE Others Each Max-Pct	.050
OT Others Tot Max-Pct	.150	Al Remainder-Pct	

## Comments

# MATERIAL TEST REPORT

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Page : 2  
Heat/Lot : 351511  
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## CERTIFICATION

Pechiney Rolled Products / Ravenswood Operations certifies that metal shipped under this order has been inspected and tested and found in conformance with the requirements of the applicable specifications as indicated herein. any warranty is limited to that shown on PRP(s) standard General Terms and Conditions of Sales. Test reports are on file, subject to examination

PECHINEY ROLLED PRODUCTS  
RAVENSWOOD OPERATIONS - RAVENSWOOD, WV. 26164

QA by MARK PARSONS 03/16/2005

## Miscellaneous Data

Control #: 90263879 Date: 07/27/05  
S.O. Number :590 365410 4  
AL SHT TL QQA250/8 5052H32

Customer P.O.: 227136

The Chemical Analysis and Mechanical Test data was received via EDI from the above mentioned vendor.

INTEGRIS METALS, LTD.